



Hardalloy[®] M-932

HARD SURFACING ELECTRODE

Build-UP

Replaces Preliminary

220-H INDEX: 981201

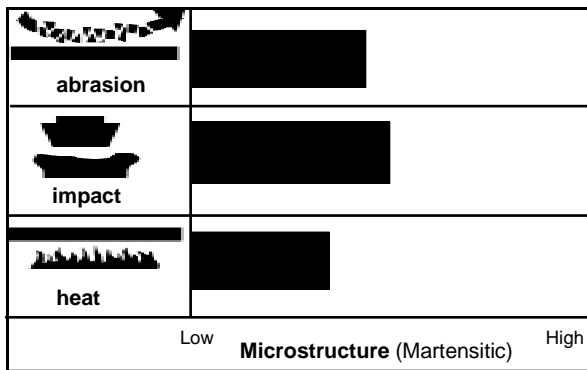
DESCRIPTION:

Hardalloy M-932 deposit is martensitic alloy with good toughness and abrasion resistance designed for all weldable steels other than austenitic stainless or manganese steels. Deposits are just within machinable range.

OPERATIONAL CHARACTERISTICS:

Arc characteristics similar to that of a low alloy stick electrode. Excellent arc control and smooth transfer. All-position capable.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis

Carbon (C)	0.13
Manganese (Mn)	0.80
Silicon (Si)	0.40
Chromium (Cr)	2.20
Molybdenum (Mo)	1.00
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

	Number of Layers	As-Deposited on	
		#132 Rail/1080 Steel†	1020 Steel
Hardness	1	38 Rc	33 Rc
	2	39 Rc	36 Rc
	3	38 Rc	38 Rc
Tensile Strength 145,000 psi (1001 MPa)			
Can be flame cut			

† 700°F preheat and interpass temperature

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



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RECOMMENDED OPERATING PARAMETERS:

Diameter Inches	Diameter mm	Type of Power	Minimum Amps	Optimum Amps	Maximum Amps
1/8	3.2	DCEP* or AC	110	120	130
5/32	4.0	DCEP* or AC	160	170	180
3/16	4.8	DCEP* or AC	210	220	230
7/32	5.6	DCEP* or AC	250	260	270
1/4	6.4	DCEP* or AC	290	300	310

* Preferred

AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches	Diameter mm	Length		10-lb. Can	12-lb. Can
		Inches			
1/8	3.2	14	355	S540744-033	-
5/32	4.0	14	355	S540751-033	-
3/16	4.8	14	355	S540758-033	-
7/32	5.6	18	457	-	S540770-057
1/4	6.4	18	457	-	S540781-057

APPLICATIONS:

- Crane Wheels
- Railroad Frogs and Switch Points
- Low Alloy Steel Railroad Crossovers
- Steel Shafts
- Tractor Undercarriage Idlers and Rollers

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